

Date: Thursday, 11/9/2006 4:36:59 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI-ACCESS STEP RH (FOLDING)	
Job Number	: 29385		Part Number	: D412630034	
Estimate Number	: 12568		Drawing Number	: IIN D412-630 REV K	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/9/2006 S.O. No. : N/A		Drawing Revision	: K	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/27/2006 Qty: 3 Um: Each	
Previous Run	: N/A		Type	: LARGE FAB ASSY	
Written By	:		3		
Checked & Approved By	:		Signature 06 11 10		
Comment	: Est. Rev:A		New Issue 06-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG001	Ke 06.11.13
2.0	D2012107	Clevis	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch	
X	1 D2012-107	Clevis	B 27522 -
3.0	D2803042	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
X	1 D2803-042	Bracket Assembly RH	B 29392 -
4.0	D2804042	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
X	1 D2804-042	Bracket Assembly RH	B 26252 , B 25920 x2 -

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 29385

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description	Batch
2	D2807	Gas Spring	<u>B 28488</u> -

6.0 D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	<u>B 09396</u> -

7.0 D3562042

STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-042	Step Weldment RH	<u>B 30575 B 31445</u>

8.0 D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	<u>B 28455</u> -

9.0 AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	<u>M101189</u> -

MF 07-03-26

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 29385

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN8C16	Bolt	<u>m100695</u> -

11.0 AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN310C8	Nut	<u>m100433</u> -

12.0 MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description	Batch
2	MS24665-302	Cotter Pin (or AN380C3-4)	<u>m16941</u> -

13.0 NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	NAS1515H3	Washer	<u>m100993</u> -

14.0 NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H5L	Washer	<u>m100680</u> -

MF. 07-03-26

W/O:		WORK ORDER CHANGES							
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Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:
 QA: N/C Closed: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H8	Washer	<u>M101331</u> -

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
4	MS21043-3	Nut	<u>M102545</u> -

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	<u>M101390</u> -

MF 07-03-26

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M10472

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: M17045

MF

07-03-26

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/26 (3)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

SO 07/03/25

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	<u>B26921</u> 2X <u>B27285</u> 4X

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	<u>B26160</u> 2X <u>B27286</u> 4X

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	<u>B26758</u> 1X <u>B27287</u> 2X

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	<u>B26604</u> 2X <u>B27290</u> 4X

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	<u>1/03/25</u> SO

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 29385

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1	AN4C6A	Bolt <i>M19512 3X</i>								
26.0	AN4C10A	Bolt								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)</p> <p>Bolt</p> <p>Pick: Packing Kit</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>AN4C10A</td><td>Bolt</td><td><i>M10518 1X</i></td></tr></tbody></table> <p><i>M100273 2X</i></p>			Qty	Part Number	Description	Batch	1	AN4C10A	Bolt	<i>M10518 1X</i>
Qty	Part Number	Description	Batch							
1	AN4C10A	Bolt	<i>M10518 1X</i>							
27.0	AN4C15A	Bolt								
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)</p> <p>Bolt</p> <p>Pick: Packing Kit</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>AN4C15A</td><td>Bolt</td><td><i>M100036 2X</i></td></tr></tbody></table> <p><i>M100477 4X</i></p>			Qty	Part Number	Description	Batch	2	AN4C15A	Bolt	<i>M100036 2X</i>
Qty	Part Number	Description	Batch							
2	AN4C15A	Bolt	<i>M100036 2X</i>							
28.0	AN44C7A	Eyebolt								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)</p> <p>Eyebolt</p> <p>Pick: Packing Kit</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>AN44-C7A</td><td>Eyebolt</td><td><i>M19620 3X</i></td></tr></tbody></table>			Qty	Part Number	Description	Batch	1	AN44-C7A	Eyebolt	<i>M19620 3X</i>
Qty	Part Number	Description	Batch							
1	AN44-C7A	Eyebolt	<i>M19620 3X</i>							
29.0	AN5C15A	Bolt								
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)</p> <p>Bolt</p> <p>Pick: Packing Kit</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>AN5C15A</td><td>Bolt</td><td><i>M1867 2X</i></td></tr></tbody></table> <p><i>M100229 4X</i></p>			Qty	Part Number	Description	Batch	2	AN5C15A	Bolt	<i>M1867 2X</i>
Qty	Part Number	Description	Batch							
2	AN5C15A	Bolt	<i>M1867 2X</i>							
30.0	NAS1515H4	Washer								
<p>Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)</p> <p>Washer</p> <p>Pick: Packing Kit</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>7</td><td>NAS1515H4</td><td>Washer</td><td><i>M105680 7X</i></td></tr></tbody></table> <p><i>M101428 14X</i></p>			Qty	Part Number	Description	Batch	7	NAS1515H4	Washer	<i>M105680 7X</i>
Qty	Part Number	Description	Batch							
7	NAS1515H4	Washer	<i>M105680 7X</i>							

7/03/06 50

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: TP Date: 07/03/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 29385

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M19568-7X

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M100601 4X

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	M18535 3X

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



10/03/26

③ 59

Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev: DMAP

10/03/26 ③

36.0 QC21 FINAL INSPECTION/W/O RELEASE



③

10/03/26

Job Completion



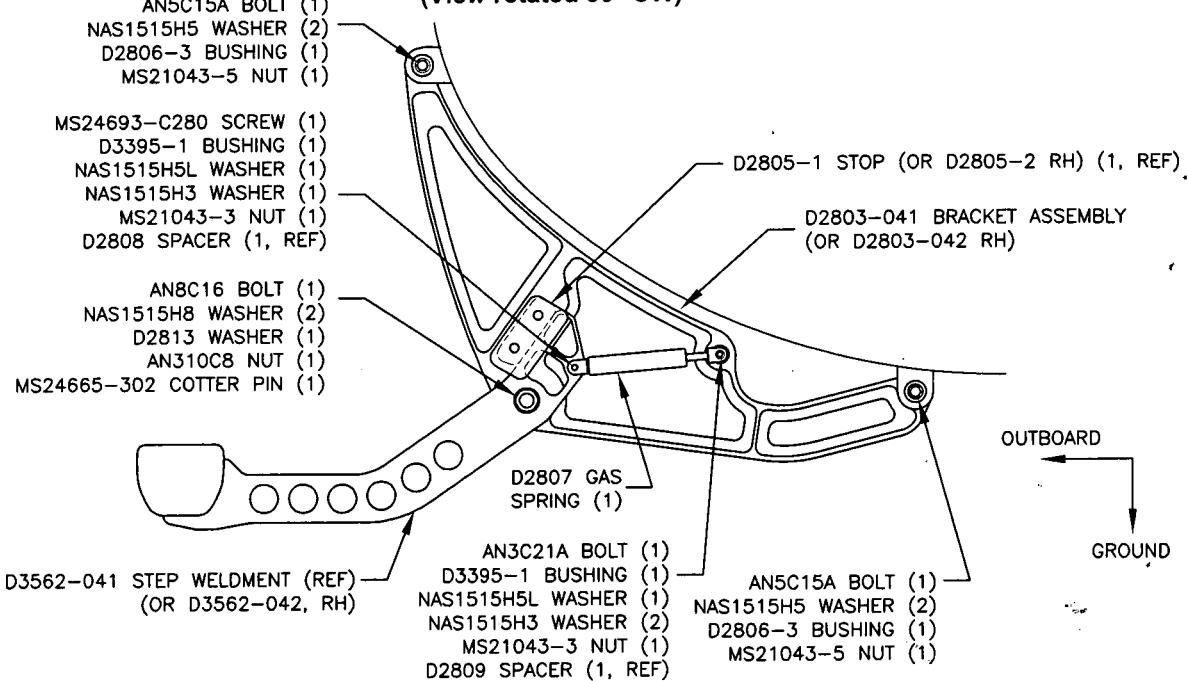
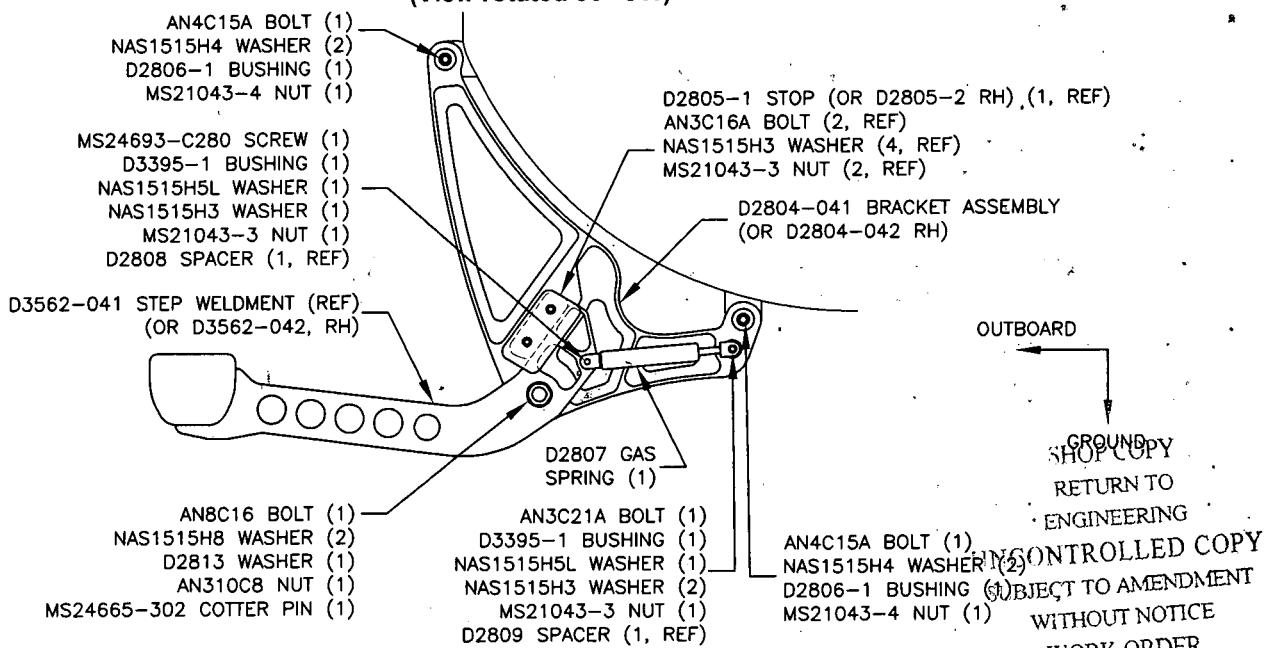
10/03/26

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

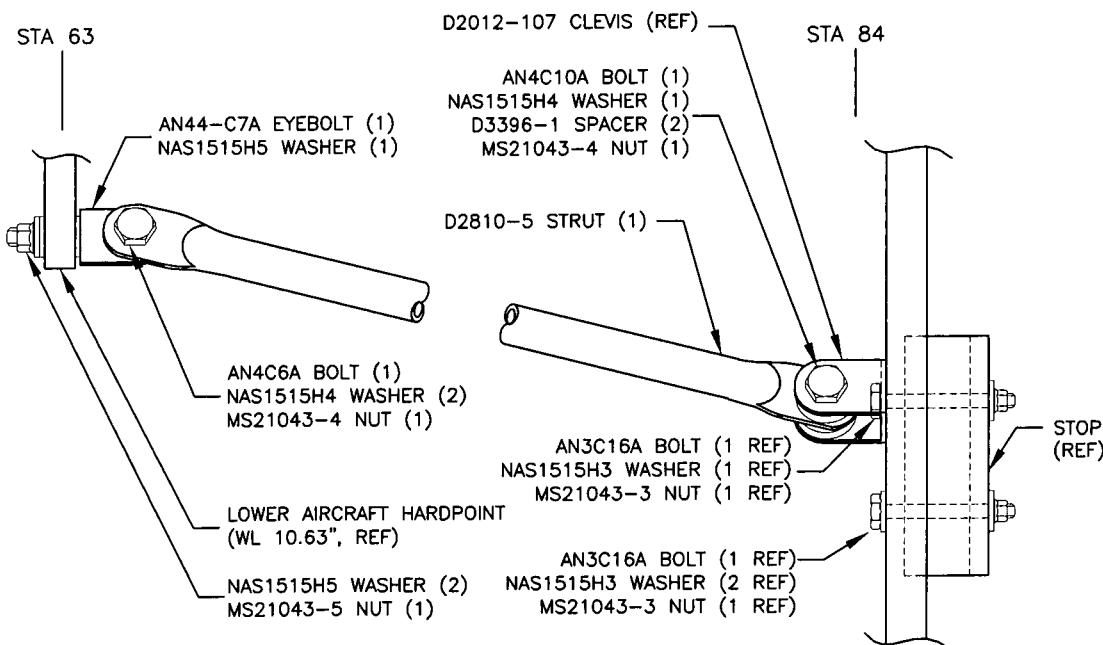
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

**FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step™* Installation
(NOT TO SCALE)**



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Revision: **K**
Date: 06.10.05

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
			1	D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807	GAS SPRING
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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